

**Work Order ID 61437**

Wednesday, August 25, 2010 10:30:26 AM



Page 1

Item ID: D206-781-151KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop



Start Date: 8/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-8-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D206-781

Rev D

0.00

P/D →

100



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-781-151KIV  
CHG 001

Solu1/2

AJ der B6 10-11-10

110



Packaging

Packaging

Pick Kit

0.00

Righ/2 0

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Solu1/2

-FO

W/O: 61437

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/12	#100	Perf. Change update laser box to have correct information	JK	10.11.15		S	10/11/12

Part No: D206-781-151 K1✓ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Work Order ID 61437**

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Item ID: D206-781-151KIV

Accept



Setup Start



Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop



Start Date: 8/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

Memo  
Identify and pack for shipping as per PPP D206-781-151KIV  
Location: \_\_\_\_\_  
PPP rev*B*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Aug 25/10**10/11/15**U-0-11-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

Wednesday, August 25, 2010 10:30:30 AM

Page 1

Work Order ID: 61437



**Parent Item:** D206-781-151KIV



**Parent Item Name:** Vertical Tunnel-Ivory

**Start Date:** 8/25/2010

**Required Date:** 9/1/2010

**Comments:** IPP RevA: New issue DD verified by:EC

**Start Oty: 1.00**

Required Qty: 1.00

**Start Qty: 1.00**

**Required Qty:** 1.00

Al<sub>60</sub>Y-63-130 f<sup>10</sup> m110482 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/12	#100	Perm. Change ADD aty 2 cut + length b cut b for D3800-1-100-800 and D3800-1-100-800.					S 10/11/12
10/11/12	#100	Missing parts from Parts list to work order Pick sheet - ADD ALSA-632-180 atm x6 in <u>110462</u> to KIT <u>10/11/12</u> w/ Date w/o + BOM. ADD copy of new BOM for ref.					S 10/11/12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, August 25, 2010 10:30:30 AM

Page 2

Work Order ID: 61437



Parent Item: D206-781-151KIV



Parent Item Name: Vertical Tunnel-Ivory

Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3822-1KIV



Vertical Tunnel, LH-Ivory

Manufactured	No	Each	1.0000	1	1
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*✓*

D3822-2KIV



Vertical Tunnel, RH-Ivory

Manufactured	No	Each	1.0000	1	1
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*✓*

D3822-3KIV



Vertical Tunnel, Aft Center-Ivory

Manufactured	No	Each	1.0000	1	1
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*✓*

D3822-5KIV



Vertical Tunnel, Top-Ivory

Manufactured	No	Each	4.0000	1	1
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*✓*

D3822-7KIV



Vertical Tunnel, Lower-Ivory

Manufactured	No	Each	0.0000	1	1
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*✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 3

Wednesday, August 25, 2010 10:30:30 AM

Work Order ID: 61437



Parent Item: D206-781-151KIV



Parent Item Name: Vertical Tunnel-Ivory

Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 1.00

Required Qty: 1.00

NAS388-6-12P

Purchased

No

Each

22.0000

14

14

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST278	22	
-------	----	--

111310	22	
--------	----	--

Each		
------	--	--

75.0000		
---------	--	--

4		
---	--	--

11/3/10

4

*CL*

NAS388-6-8P

Purchased

No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST278	75	
-------	----	--

113470	75	
--------	----	--

Each		
------	--	--

47.0000		
---------	--	--

18		
----	--	--

11/3/10

18

*CL 09/12 0*

NAS391B6P

Purchased

No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST278	47	
-------	----	--

112616	47	
--------	----	--

Each		
------	--	--

47		
----	--	--

11/26/10

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 5.1.3 D206-781-111/-113/-115/-117 UTILITY KITS

Qty -111	Qty -113	Qty -115	Qty -117	Part Number	Description
X				D206-781-111	UTILITY KIT W/O ROTOR BRAKE
	X			D206-781-113	UTILITY KIT W/ ROTOR BRAKE
		X		D206-781-115	UTILITY KIT W/O ROTOR BRAKE, LITTER KIT COMPATIBLE
			X	D206-781-117	UTILITY KIT W/ ROTOR BRAKE, LITTER KIT COMPATIBLE
1		1		D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	1		1	D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
1	1	1	1	D206-781-151	VERTICAL TUNNEL KIT
1	1	1	1	D206-781-161	REAR OVERHEAD KIT
1	1			D206-781-171	HAT BIN KIT
		1	1	D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE

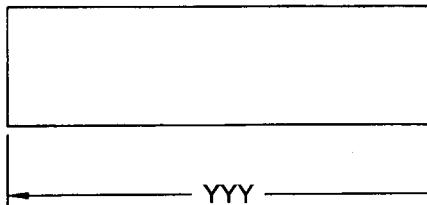
## 5.1.4 D206-781-141/-143/-151/-161/-171/-173 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Part Number	Description	
X						D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT	
	X					D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT	
		X				D206-781-151	VERTICAL TUNNEL KIT	
			X			D206-781-161	REAR OVERHEAD KIT	
				X		D206-781-171	HAT BIN KIT	
					X	D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE	
1						D3821-1	PANEL - W/O ROTOR BRAKE	
	1					D3821-3	PANEL - W/ ROTOR BRAKE	
4	4					NAS388-6-8P	SCREW	
4	4					NAS391B6P	WASHER	
		1				D3822-1	VERTICAL TUNNEL, LH	
		1				D3822-2	VERTICAL TUNNEL, RH	
		1				D3822-3	VERTICAL TUNNEL, AFT CENTER	
		1				D3822-5	VERTICAL TUNNEL, TOP	
		1				D3822-7	VERTICAL TUNNEL, LOWER	
		2				D3800-1-100-800	LOOP STRIP	
		2				D3800-3-100-800	HOOK STRIP	
		4				NAS388-6-8P	SCREW	
		14				NAS388-6-12P	SCREW	
		18				NAS391B6P	WASHER	
		4				ALS4-632-80	INSERT	
		8				ALS4-632-130	INSERT	
			1			D3823-1	REAR OVERHEAD, LH	
			1			D3823-2	REAR OVERHEAD, RH	
			1			D3823-3	REAR OVERHEAD, CENTER	
			10			AN525-10R24	SCREW	
			10			NAS43DD3-68	SPACER	
				1		D3824-1	HAT BIN	
					1	D3824-3	HAT BIN	
				6	6	D3851-1	DOUBLER	
					4	4	AN525-10R10	SCREW

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Revision: D  
Date: 09.07.07

# SPECIFICATION CONTROL DRAWING



XXX REFERENCE ONLY  
B

DESCRIPTION: HOOK AND LOOP STRIP WITH ADHESIVE BACK

SPECIFICATION: D3800-1-XXX-YYY LOOP STRIP (ie. SOFT VELCRO STRIP)  
D3800-3-XXX-YYY HOOK STRIP (ie. HARD VELCRO STRIP) B

WHERE 'XXX' IS WIDTH IN HUNDREDTHS OF AN INCH  
AND 'YYY' IS LENGTH IN TENTHS OF AN INCH

EG. 1" WIDE BY 2.5" LONG LOOP STRIP = D3800-1-100-025  
2" WIDE BY 10.0" LONG HOOK STRIP = D3800-3-200-100

PART NUMBER	WIDTH	PURCHASE
D3800-1-100-YYY LOOP STRIP	1.0	McMASTER CARR P/N: 9776K122, 9776K126, 9776K18, 9776K28, 9776K131, 9776K38
D3800-3-100-YYY HOOK STRIP	1.0	McMASTER CARR P/N: 9776K97, 9776K113, 9776K13, 9776K23, 9776K117, 9776K33
D3800-1-100-YYY & D3800-3-100-YYY (PURCHASED AS COMBINATION PACK)	1.0	McMASTER CARR P/N: 9776K72, 9776K76, 9776K79, 9776K84, 9776K88, 9776K93
D3800-1-200-YYY LOOP STRIP	2.0	McMASTER CARR P/N: 9776K123, 9776K127, 9776K19, 9776K29, 9776K132, 9776K39
D3800-3-200-YYY HOOK STRIP	2.0	McMASTER CARR P/N: 9776K98, 9776K114, 9776K14, 9776K24, 9776K118, 9776K34
D3800-1-200-YYY & D3800-3-200-YYY (PURCHASED AS COMBINATION PACK)	2.0	McMASTER CARR P/N: 9776K73, 9776K77, 9776K81, 9776K85, 9776K89, 9776K94

NOTES:

- 1) MATERIAL: WOVEN NYLON HOOK AND LOOP WITH ADHESIVE BACK  
BEIGE COLOR  
ACCEPTABLE SUPPLIERS PER ABOVE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED  
08-10-15

B	ADD 1" WIDTH OPTION, "XXX-YYY" WAS "XXX", ADD ADDITIONAL McMaster PART NUMBERS	CP	08.09.09
A	NEW ISSUE	CP	08.06.18
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO.		
MFG. APPR.	D3800		
APPROVED	REV. B		
DE APPR.	SHEET 1 OF 1		
DATE	TITLE		
	HOOK AND LOOP STRIP		
08.09.09	SCALE		
	NTS		
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